Work Order ID 105137 Tuesday, July 23, 2013 1:12:15 PM			*105	137	' *			PU	3 b		Page 1		
Revision ID: Item Name:	D4130-9 Aft Cargo Floor Protector	/2	Accept	*N9) ()	<u>0</u> 040	100)* 5	Setup	Start Stop	I ZI	S1* S2*	
Start Date: Required Date: 'Reference:	7/23/2013 Start Qty: 1.00 7/23/2013 Req'd Qty: 1.00	~ *1* *1*			t Item l tomer:							,	
	Process Plan: MF.					ate:		I	Run	Start Stop	171	R1* R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Too	ol ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr											<u> </u>	
D4130	В												
*100 *100* Waterjet FLOW CNC Waterjet	Dwg Rev: Prog Rev:	R	0.00			ŧ		3_		0_		A. 13.07.23	
110 *110* QC Quality Control	QC2- Inspect parts off Memo	machine FAI/FAIB	0.00					3		<i></i>		Au 13.07.23	
120 *120* QC Quality Control	QC8- Inspect parts - se	cond check	0.00 27	; 24				3			:		

							DQA:	Date:	
NCR: Yes	/ No			WORK ORDER NON-C	ONFORM	MANCE / UPDATE	QA Closed:	Date:	
Work Order: Part No. NCR No.				DISPOSITION Rework Scrap Use-as-is Work Order Update	'\$' [^]	Skid-tube Crosstube Small Fab Finishing Composite	_	/PROCESS Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Description of work order update	Initial	Action	Sign &		
Cause	Date	Step	Qty	or Non-conformance	Chief Eng	Description	Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator]								
Material									

FAULT CATEGORY Landing Gear General Bend Ovalized Pressure/Forced Bending Grain BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Weld Broken/Damaged Inspection Incomplete Part Incorrect Cracks Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Crushed/Crimped Part Moved Maintenance Cuffs Contamination Countersink Mislabeled Positioned Wrong Heat Treat Other Misread Power Loss/Surge Inspection Strip in Tube Cut Too Short Ripples in Bend Drill Holes Offset Out of Calibration Torque Waves in Extrusion Drawing Turning Sequence Out of Sequence Finish Wave/Twist in Tube Folio Outside Dimensions

Setup
Other
Process
Supplier
Training
Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 105137 *105137* Page 2 Tuesday, July 23, 2013 1:12:15 PM Item ID: D4130-9 Accept *N900040100* Setup Start **Revision ID:** Item Name: Aft Cargo Floor Protector Start Otv: 1.00 **Start Date:** 7/23/2013 **Cust Item ID:** Required Date: 7/23/2013 Req'd Qty: 1.00 **Customer:** Reference: Run Approvals: Process Plan: Tooling: Date: Date: Stop QC: Date: SPC(Y/N): Date: Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Accept Reiect Reject Insp. Work Center ID Description **Run Hours** Code Otv Otv Number Stamp Identify as per dwg & Stock Location: PPP 130 0.00 105134 3 *120* Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 *140* OC 0.00 Memo

Ouality Control

13-7-34 (3-7-34

NCR.	Ves	1	Nο	

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	

		,									QA Closed:	Da	te:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part N	- oo					Rework Scrap		Skid-tube Crosstube Machining Small Fab				Water Jet d. Eng. Coor.		uality
NCR N	No					Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier		Other
Root	\Box				Descri	ption of work order update	In	itial	Ac	ction	Sign &			
Cause		Date	Step	Qty	•	or Non-conformance	Chie	ef Eng	Desc	cription	Date	Verification	n QC I	nspector
Doc/Data														
Equip/Tooling														
Operator														
Material	Ш	-												
Setup														
Other							1							
Process	Ш	-												
Supplier	Ш													
Training	Ц													
Unapproved				<u> </u>			<u> </u>							
							AULT	CATE	GORY					
Landi					_	General					1			
	$\boldsymbol{\vdash}$	Bending				Bend	\vdash	Grain			Ovalized		Pressure	-
	-	Centre No	ot Conce	ntric to	o/s	BOM/Route	-	Hardwa		<u> </u>	Over/Under		—	iture/Cure
		Cracks			<u></u>	Broken/Damaged	\vdash	•	on Incomplete		Part Incorre		Weld	
	-	Crushed/0	Crimped		<u> </u>	Burrs			ions Incomplete	/Unclear	Part Lost/M	issing	Wrong S	tock Pulled
	-	Cuffs			_	Contamination	\vdash		nance	<u></u>	Part Moved			
	${f o}$	Heat Trea			L	Countersink		Mislabe		<u> </u>	Positioned V		┌ ┐	
	-	Inspection		Tube	<u> </u>	Cut Too Short	\mathbf{H}	Misread	i .		Power Loss/	Surge	Other	
	\vdash	Ripples in				Drill Holes		Offset						
	\vdash	Torque W			n L	Drawing			Calibration					
	Ш	Turning S	equence	!		Finish	-		Sequence					
1	1 1	Wave/Tw	ist in Tul	he		Folio	1 10	Outside	Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

Tuesday, July 23, 2013 1:12:14 PM

Work Order ID:

105137

Parent Item:

D4130-9

Parent Item Name:

Aft Cargo Floor Protector

Start Date: 7/23/2013

Required Date: 7/23/2013

Start Qty: 1.00

Required Qty: 1.00

Comments:

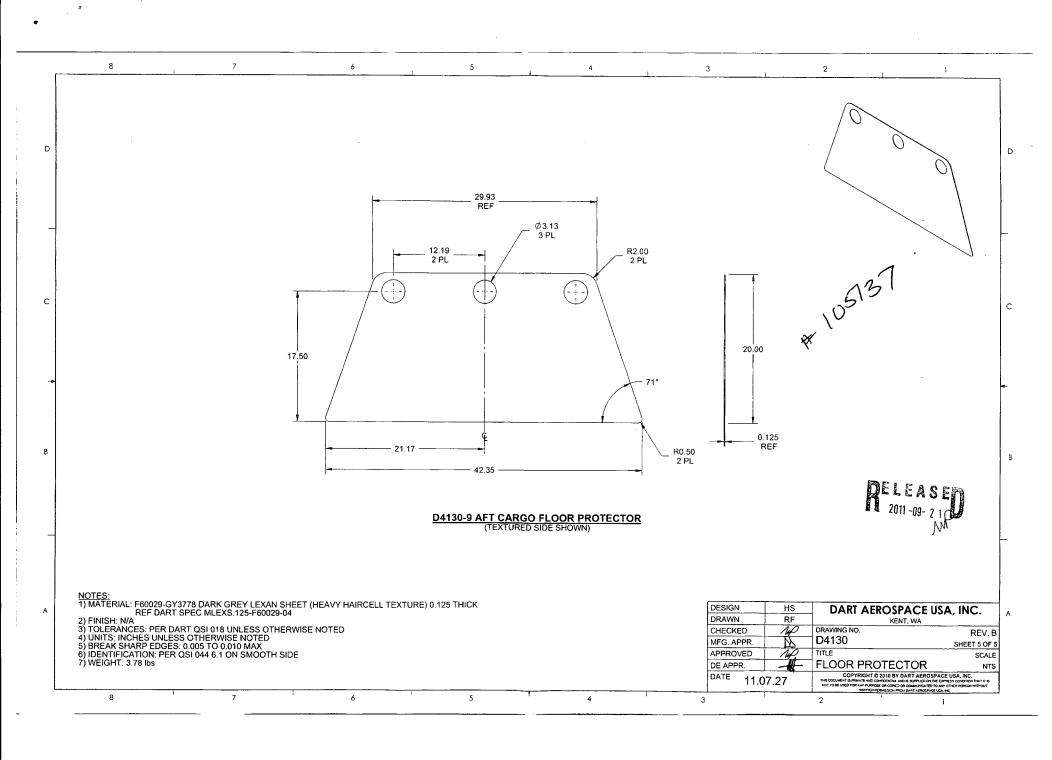
IPP Rev:A 10.06.08 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 GE PLASTICS LEXAN SE		Purchased	No			100	sf	307.4920	5.882	6.92	Ae	6 . (7)_
				Location MAT018		<u>Loc Qty</u> 307.492	Lo	c Code				13.0	07.2
				124	866	307.492			12	4866			

				DQA:	Date:	
NCR:	Yes / No	n	WORK ORDER NON-CONFORMANCE / UPDATE	.		

										QA Closed:	Date	:
Work Orde	er:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N						Rework Scrap Use-as-is Work Order Update	- 1	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Initial	A	ction	Sign &	Ĭ	
Cause	1	Date	Step	Qty		or Non-conformance	Chief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling											-	
Operator		İ										•
Material												
Setup												1
Other												
Process												
Supplier							1					
Training												
Unapproved						·				<u> </u>		
						<u> </u>	AULT CATI	GORY				
Landi	ng Gea				_	General				7	-	_
	$oldsymbol{oldsymbol{ o}}$	nding			L	Bend	Grain		_	Ovalized	<u> </u>	Pressure/Forced
	\vdash		t Concer	ntric to (D/S	BOM/Route	Hardw			Over/Under	_	Temperature/Cure
	$oldsymbol{oldsymbol{ o}}$	acks				Broken/Damaged		tion Incomplete	_	Part Incorre		Weld
	-		Crimped			Burrs		tions Incomplete	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cu					Contamination	⊢	enance		Part Moved		
		at Trea			<u> </u>	Countersink	Mislab			Positioned V		7
	-	-	Strip in	Tube	<u> </u>	Cut Too Short	Misrea		<u> </u>	Power Loss/	'Surge	Other
	— '	ples in			<u> </u>	Drill Holes	Offset					
		•	aves in E		՝ _	Drawing	\mathbf{H}	Calibration				
	-		equence		L	Finish	 	Sequence				·
1	l W	Wave/Twist in Tube Folio			Folio	Outsid	e Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



											DQA:	Date:		
NCR: Y	'es	/ No				WORK ORDER NON-C	CONF	NFORMANCE / UPDATE QA Closed: Date:						
Work Orde	er:					DISPOSITION AGAINST DEPARTMENT/PROCESS								
Part No			Rework Skid-tube Crosstube Machining Small Fab Use-as-is Thermoforming Finishing Composite			<u> </u>	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other						
Root					Descri	ption of work order update	Ini	tial	Ac	tion	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Chie	f Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data														
Equip/Tooling														
Operator														
Material														
Setup														
Other												:		
Process							1							
Supplier														
Training			[
Unapproved										•				
						F	AULT	CATE	GORY					

Landing Gear General Bend Grain Ovalized Pressure/Forced Bending Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S BOM/Route Hardware Broken/Damaged Inspection Incomplete Part Incorrect Weld Cracks Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Burrs Crushed/Crimped Maintenance Part Moved Cuffs Contamination Mislabeled Positioned Wrong Countersink Heat Treat Other Cut Too Short Misread Power Loss/Surge Inspection Strip in Tube Offset Ripples in Bend Drill Holes Out of Calibration Torque Waves in Extrusion Drawing Out of Sequence Finish Turning Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

DART AEROSPACE LTD	Work Order: 1057	37
Description: Aft Cargo Floor Protector	Part Number:	04130-9
Inspection Dwg: D4130 Rev: B	Pa	ge 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.13	+0.012/-0.001	3,12	i i		Ly	JKm-0)
12.19	+/-0.030	12.19	_		7	JKM~06
29.93	+/-0.030	29.93	_		T	
17.50	+/-0.030	17.50	_		T	
21.17	+/-0.030	21.17	-		7	
42.35	+/-0.030	4235	_		T	UKM-06
20.00	+/-0.030	20.00	-		T	
0.125	+/-0.010	.128	_		V	JKM-01
<u></u>						
		-				
		-				

		240		
Measured by: Ae	Audited by:	27	Preliminary Approval:	
Date: 13 107,23	Date:	177.24	Date:	

Rev	Date	Change	Revised by	Approved
Α	10.10.25	New Issue	KJ IN	- //
В	12.05.15	Dwg Rev updated	KJ 🗫	1111
			- //	4

									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-CONFORMANCE / UPDATE				QA Closed:	Date:	
Work Order:					DISPOSITION	AGAINST DEPARTMENT/PROG				/PROCESS	
Part No. NCR No.					Rework Scrap Use-as-is Work Order Update	The	Skid-tube Crosstube Small Fab Thermoforming Finishing Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other
Root		T		Descri	tion of work order update	Initial	1	Action	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief En	g De	scription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling						1					
Operator [İ									
Material [İ							
Setup		1									1
Other			*								
Process			*								
Supplier		-				İ					, *
Training											
Unapproved			ļ. <u> </u>							<u> </u>	
					<u> </u>	AULT CAT	rEGORY				
Landir	ng Gear				General				7		7
	Bending			_	Bend	Grain	า	_	Ovalized	ļ	Pressure/Forced
	Centre Not Concentric to O/S				BOM/Route	Hard	Hardware			tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspe	Inspection Incomplete			ct	Weld
:	Crushed/Crimped				Burrs	Instru	Instructions Incomplete/Unclear			issing	Wrong Stock Pulled
	Cuffs				Contamination	Mair	Maintenance				
	Heat Treat				Countersink	Misla	beled		Positioned \	N rong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio